Work Order ID 74611-

Monday, October 03, 2011 4:04:16 PM



Page 1

Item ID: D3195-041 Accept Setup Start Revision ID: Stop Bracket Assembly Item Name: Start Date: 10/3/2011 Start Oty: 6.00 Cust Item ID: Reg'd Oty: 6.00 Required Date: 10/5/2011 Customer: Reference: Start Run Date://-/0-1/ Approvals: Process Plan: Tooling: Date: Stop OC: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Reject Tool ID Reject Tool# Plan Accept Insp. Work Center ID Description Oty Run Hours Code Oty Number Stamp Draw Nbr Revision Nbr D3195 Rev A 100 0.00 BAND SAW Bandsaw 0.00 Memo SL 11-10-12 Jeaspa Bandsaw Cut blanks: (0.75" x 2.00") x 3.60" long 110 0.00 HAAS CNC VERTICAL MACHINING #1 HAAS 1 0.00 Memo Machine D3195-1 as per Folio FA334 and Dwg D3195 Identify as D3195-HAAS CNC vertical machine #1 1 Deburr QC2- Inspect parts off machine FAI/FAIB 120 0.00 SL 1844 11-10-19 0.00 Memo Quality Control

Dart Ae	rospace Lt	d							
W/O:			WO	RK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No		olution:	Disposition	gory: Non-CONFORMANG	A: N/C C	losed:			
10000000				Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti	cation ion C	Approval Chief Eng	Approva QC Inspecto

Work Order ID 74611

Monday, October 03, 2011 4:04:16 PM



Page 2

Item ID:

D3195-041

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Required Date: 10/5/2011

Stop

Start Date:

10/3/2011

Start Otv: 6.00 Reg'd Qty: 6.00



Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Oty

Start

OC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ Run Hours

0.00

Ha 11/10/14

Tool#

Plan

Code

Reject Accept Otv

Reject Number

Insp. Stamp

140

HandFinish

Hand Finishing

Chemical Conversion Coat per OSI005 4.1

0.00

Memo

0.00

6X9mf11/10/

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo START TIME:

3200 FINISH TIME:

DM-\$11/10/10

W118480

Work Order ID 74611

Monday, October 03, 2011 4:04:16 PM



Page 3

Item ID:

D3195-041

Accept

Setup Start



Revision ID:

Item Name:

Bracket Assembly

Start Date:

10/3/2011

Start Qtv: 6.00

Required Date: 10/5/2011 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Date:

Run

Start

Stop



QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Stop

6 De 11-10-19.



Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

0.00

0.00

0.00

Tool ID

Tool# Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

170

Small Fab Small Fab

Memo

0.00

1-Lightly Sand bonding surface 2-Bond D3195-5 into D3195-1 as per Dwg

D3195 A/RContact Cement

SCOTCH-WELD

HIGH PERFORMANCE 3M 1300/1300L

Small Fab

QC5- Inspect part completeness to step on W/O

0.00

8 ulcolec

Memo

180

Quality Control

W/O: 71	1611-1	WORK ORDER CH	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
										

NCR:		V	WORK OR	DER NON-CONFORMANCI	E (NCR)			
		Description of NC		Corrective Action Section B	Verification	Approval	Approval QC Inspector	
DATE	STEP	Section A	Initial Chief Eng	Chief Eng Chief Eng		Section C		Chief Eng
11.10.19	170	Open P.A.R. to update dug \$3199	5 P 11.20,27 OS/14/2	PAR 11-130 OPEND JULIO.31	(6031	Tillor	11.10.27 14.042	MM
		P1.01.11 A	Qui-12				901	
E								

Work Order ID 74611

Monday, October 03, 2011 4:04:16 PM



Page 4

Item ID:

D3195-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Required Date: 10/5/2011

Bracket Assembly

Start Date:

10/3/2011

Start Qtv: 6.00

Req'd Qtv: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

OC:

Date:

Date:

Tooling: SPC (Y/N):

Date: Date:

Run

Stop



Sequence ID/ Work Center ID

190

Packaging

Operation Description

Identify as per dwg & Stock Location 246 A

Memo

Set Up/ Run Hours

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Otv

Reject Number

Insp. Stamp

Packaging

200

QC21- Final Inspection - Work Order Release

Quality Control

Memo

0.00

0.00

110 27 9K)

Dart Ae	rospace Lt	d							r.
W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
								-	
Part No):	PAR #:	Fault Categ	gory:	NCR: Yes	No DQ	A:	Date: _	
	Reso	olution:	Disposition	1:	QA: N/C	Closed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
2505-2003		Description of NC		Corrective Action Section	on B	Verifi	cation	Approval	Approva
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspecto
					(2)				

Picklist Print

Monday, October 03, 2011 4:04:21 PM

Work Order ID: 74611

Parent Item:

D3195-041

Parent Item Name: Bracket Assembly



Start Date: 10/3/2011

Required Date: 10/5/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

\boldsymbol{c}	an	* ***	and the	ts:	
•	vII		CH	13.	

IPP Rev:A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3195-5		Manufactured	No			100	Each	2.0000	1 <u>1 </u>	S	/10/	125	
				Location		Loc	Qty	Loc Code		*****	11		
				GA			2			15065	77		
					72204		2		-		_		-
M6061T6B0.750X02.00		Purchased	No			170	f	18.0850	0.3	1.89473	7		
										SL 11-1	0-12		

6061-T6 Bar .750 x 2.00

Location Loc Code Loc Qty MAT003 18.085 100742 3.271 111448 14.814

Dart	Aerospace Ltd	
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										• • • • • • • • • • • • • • • • • • • •
W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CHAN	GE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
David No.		DAD #	F 110.1		Non	V N	200		D. 4	
Part No		PAR #:								
	Re	esolution:	Disposition		_ QA: N	WC Clos	ed:		_ Date: _	
NCR:		٧	WORK ORDE	R NON-CONFORMA	ANCE	(NCR)				
DATE	STEP	Description of NC	Description of NC Corrective Action			Section B Verificat			Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
			-							
							æ			

DART AEROSPACE LTD	Work Order:	7441
Description: Bracket	Part Number:	D3195-1
Inspection Dwg: D3195 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	1	
X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.265	+/-0.010	1.265	/		Vera SI-3	•
0.242	+/-0.010	-244	/		L	
1.084	+/-0.010	1.084	/		H-G .	
R0.200	+/-0.010	.200	/		11	
R0.377	+/-0.010	-317	/			
Ø0.277	+0.005/-0.000	.214	/		n	
2.677	+/-0.005	2.674			~	
3.432	+/-0.010	3 433	/			
0.754	+/-0.010	755	/		3	
1.387	+/-0.010	1.383	/		120	
0.500	+/-0.010	.499	/		6	
0.250	+/-0.005	-249	-		9	
1.754	+/-0.010	1.753	1		^	
Ø0.191	+0.005/-0.000	191			2	

Measured by:	Sh	Audited by:	b.A	Prototype Approval:	N/A
Date:	11-10-14	Date:	11/10/14	Date:	N/A
5 5			111011		

Rev	Date	Change		Revised by	Approved
Α	04.04.20	New Issue	(P/O D412-702-011/-13)	KJ/RF	14

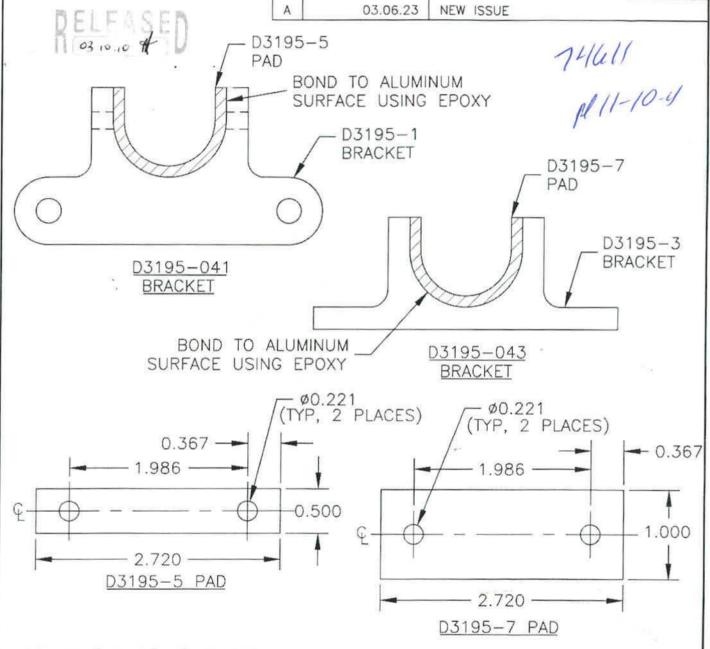
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W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								12	
					150				25
Part No:		PAR #:	Fault Categ	ory:	NCR: Yes	s No DC	A:	Date: _	
	Re	solution:	Disposition	:	QA: N/C	Closed:		Date: _	
NCR:		N	VORK ORDE	R NON-CONFORMAL	NCE (NC	R)			
	STEP	Description of NC Section A		Corrective Action Section	74.51	Verif	cation	Approval Chief Eng	Approval
DATE			Initial Chief Eng	Action Description Chief Eng	Sigr	& Sec	Section C		QC Inspector
				A					





DESIGN (DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED #	- APPROVED	DRAWING NO. D3195	REV. A SHEET 1 OF 3
DATE		TITLE	SCALE
03.06.23		BRACKET	1:1
		LEVERTON NAME OF THE PARTY OF T	



D3195-5 & D3195-7 PAD

MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK (POSSIBLE SUPPLIERS, ACCURATE RUBBER)

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

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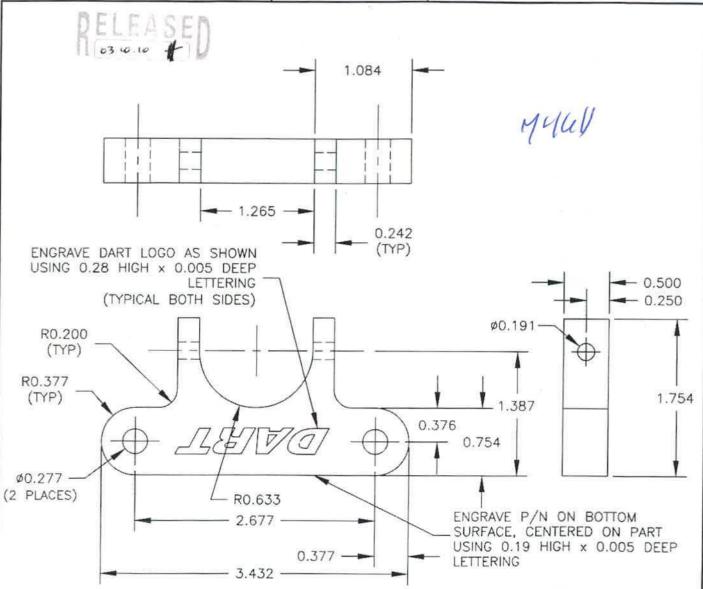
W/O:			WO	RK ORDER CHANGE	S		12-20		
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							Œ		
Part No	·	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	_ Date: _	
Resolution:			Disposition: QA: N/C Closed: Date:						
NCR:			WORK ORDE	R NON-CONFORMAN	ICE (NCR)			
D.4.7.F	0===	Description of NC		Corrective Action Section		Verification		Approval	Approval
DATE		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
				v ₂ *					

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DESIGN (P	DRAWN BY		OSPACE LTD ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3195	SHEET	REV. A
DATE		TITLE		SCALE
03.06.23		BRACKET	***	1:1



D3195-1 BRACKET

- MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) IOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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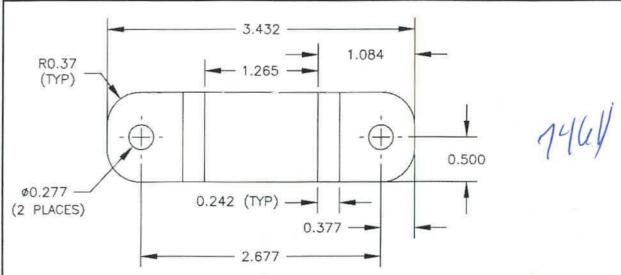
Dart Aerospace Ltd

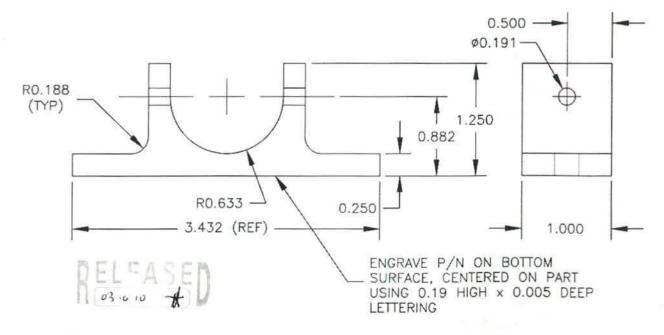
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W/O:			WO	RK ORDER CHANGE	ES				
DATE STEP			CEDURE CHAN	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
	÷.								
									41
Part No: PAR #:		PAR #:	Fault Cated	Jory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition	ı:	QA: N/C C	osed:		Date:	
NCR:		\	WORK ORDE	ER NON-CONFORMA	NCE (NCF	R)			
		Description of NC		Corrective Action Section	on B	Vorifi	cation	Approval Chief Eng	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a Date	Sec	tion C		QC Inspector
									1

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CHECKED #	APPROVED	DRAWING NO. D3195	REV. A SHEET 3 OF 3
DATE		TITLE	SCALE
03.06.23		BRACKET	1:1





D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace	Ltd
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W/O:	ТОЗРАСС		wo	RK ORDER CHANG	FS		-	Mar. 19	1100	
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
								-	30.	
								-	-	*
Part No: PAR #:		PAR #:	_ Fault Cate	gory:	NCR: Yes No DQA:			_ Date: _		
	R	esolution:	Disposition	1:	QA	N/C Clo	sed:		Date: _	
NCR:	ļ.	W	ORK ORD	ER NON-CONFORMA	ANCE	(NCR)			9	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B	Sign & Date		cation on C	Approval Chief Eng	Approval QC Inspector
			Office City	Office Eng						-
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